

# Work Order ID 88690

July-30-12 3:29:09 PM

TRIAL FIT

**\*88690\***

Page 1

Item ID: D3650-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Tunnel Top Panel Assembly  
 Start Date: 7/30/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 7/31/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3650	Rev C								
100	Pick Kit	0.00							
<b>*100*</b>									
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
<b>*110*</b>									
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per dwg D36502- Seal all mating surfaces and all gaps using Proseal 700 fire wall sealantas per dwg D3650Batch								
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

*Scrap Trial St*

**Work Order ID 88690**

July-30-12 3:29:09 PM

**\*88690\***

Page 2

Item ID: D3650-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Tunnel Top Panel Assembly  
Start Date: 7/30/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 7/31/12 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*mf*  
*12-0822*

# Picklist Print

July-30-12 3:29:09 PM

Page 1

Work Order ID: 88690

Parent Item: D3650-041

Start Date: 7/30/12

Required Date: 7/31/12

Parent Item Name: Tunnel Top Panel Assembly

Start Qty: 1.00

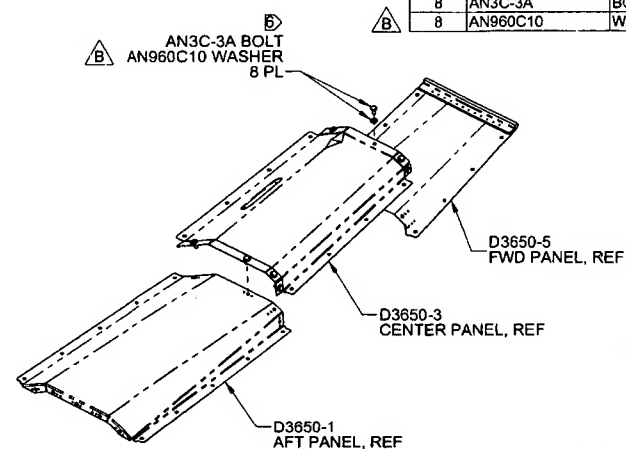
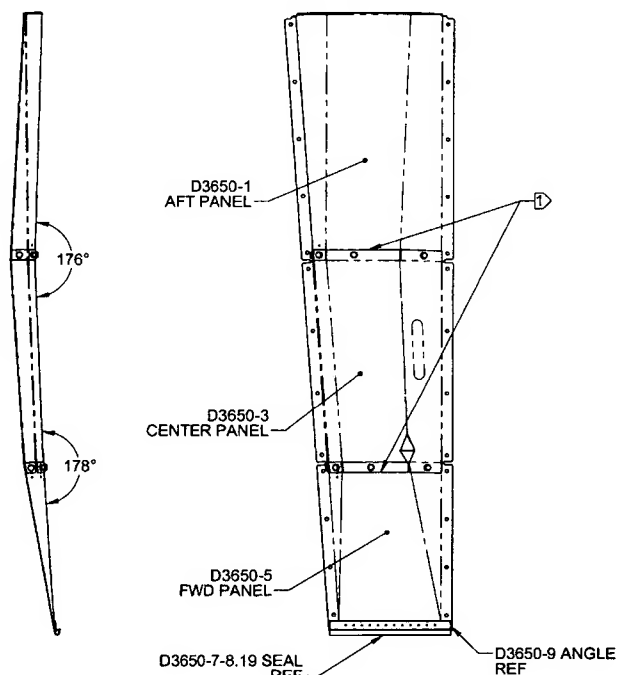
Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-11-12 EC verified by: DD  
 IPP Rev:B Ecn 1113P 08-01-22 DD verified by:EC  
 IPP Rev:C Ecn1162 08-04-02 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C3A Bolt		Purchased	No			110	Each	495.0000	8	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		70							
				118352		70							
				ST350		425							
				120187		1							
				122141		424							
D3650-1 Aft Panel		Manufactured	No			110	Each	0.0000	1	1			
D3650-3 Center Panel		Manufactured	No			110	Each	0.0000	1	1			
D3650-5 Fwd Panel		Manufactured	No			110	Each	4.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST189		4							
				65545		1							
				69549		3							
NAS1149C0363R Washer		Purchased	No			100	Each	4,911.0000	8	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				297		2000							
				122441		2000							
				ST297		2911							
				114742		2711							
				122063		200							

8 7 6 5 4 3 2 1

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER



DEO ATTACHED

UNDER REVIEW  
OK  
07.05.08  
07.06.21  
RELEASE  
07.11.07

**D3650-041 TUNNEL TOP PANEL ASSEMBLY**

- NOTES:
- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
  - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 5) IDENTIFICATION: NONE
  - 6) TORQUE FASTENERS 15 TO 25 in-lb
  - 7) WEIGHT: 3.3 lbs

088690

C	REFORMATTED TO NEW STANDARDS; RELOCATED PART LIST (ZN D2-2); ADDED SECTION VIEW J-J & REVISE DIMENSIONS (ZN B7-5, C4-5); ADDED RECESS LOCATION & REVISED DIMENSIONS (ZN C6-6, D5-6); MS20615-4M5 WAS CR3523-4-03 & NAS1149CN432R WAS AN960C4 (ZN D5-7; B5-7; B8-7)	RF	08.10.14
B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOFF TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL 1 SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS O: D3650-11/-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.14		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3650** REV. C SHEET 1 OF 9

TITLE **TOP PANEL ASSEMBLY** SCALE 1:8

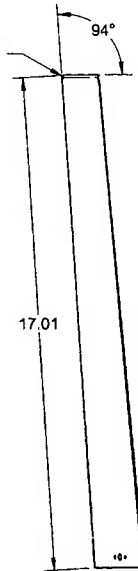
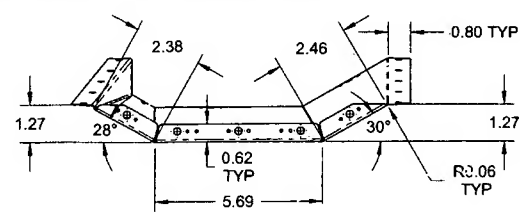
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

QTY	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE



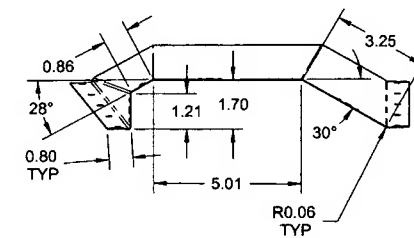
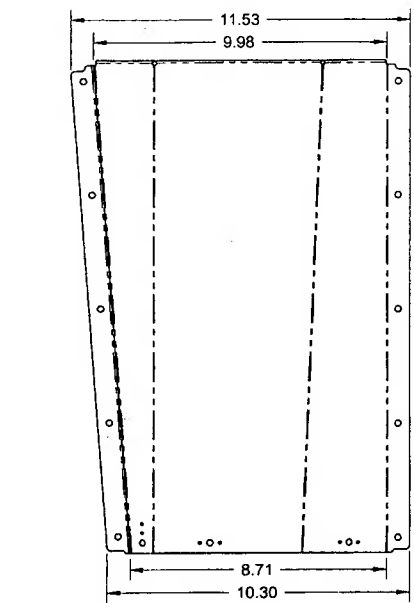
DEO ATTACHED

UNDER REVIEW  
OK 09/02/03  
09/06/03

RELEASED  
06/10/03

**D3650-1 AFT PANEL**

**D3650-1B AFT PANEL BENT PART**  
(MAKE FROM D3650-1F FLAT PATTERN)



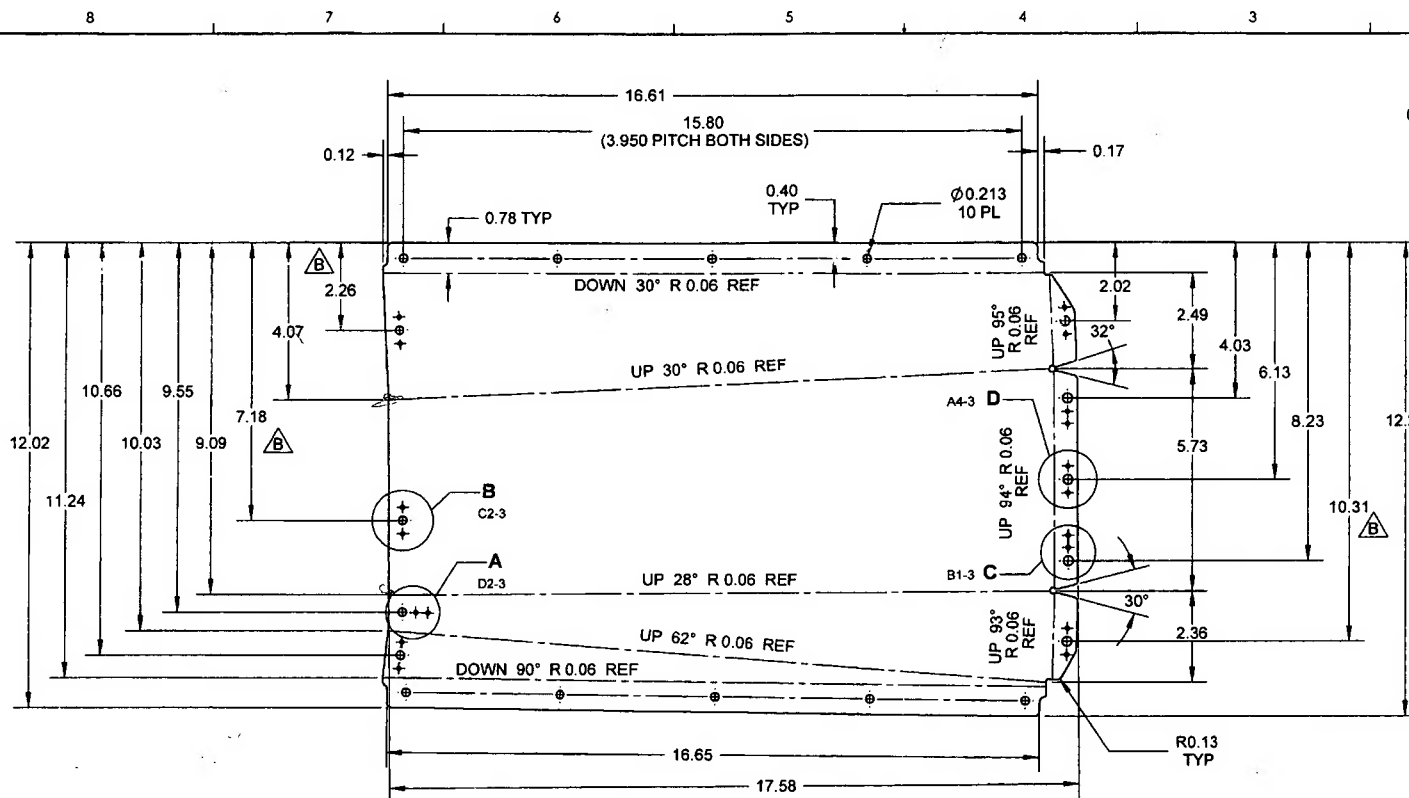
90 3.67

- NOTES:
- 1) FINISH: NONE
  - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 5) IDENTIFICATION: NONE
  - 6) WEIGHT: 1.3 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

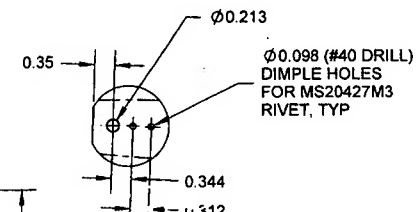




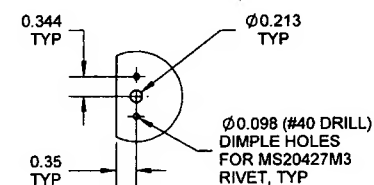
**D3650-1F FLAT PATTERN**

**NOTES:**

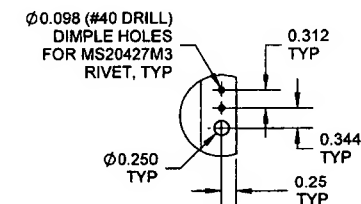
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.22 lbs



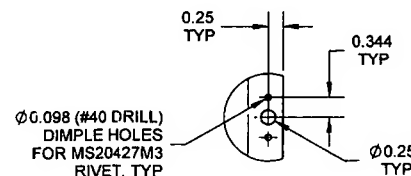
**DETAIL A** C7-3  
SCALE 1.5X



**DETAIL B** C7-3  
SCALE 1.5X



**DETAIL C** C4-3  
SCALE 1.5X



**DETAIL D** C4-3  
SCALE 1.5X

**UNDER REVIEW**

**DEO ATTACHED**

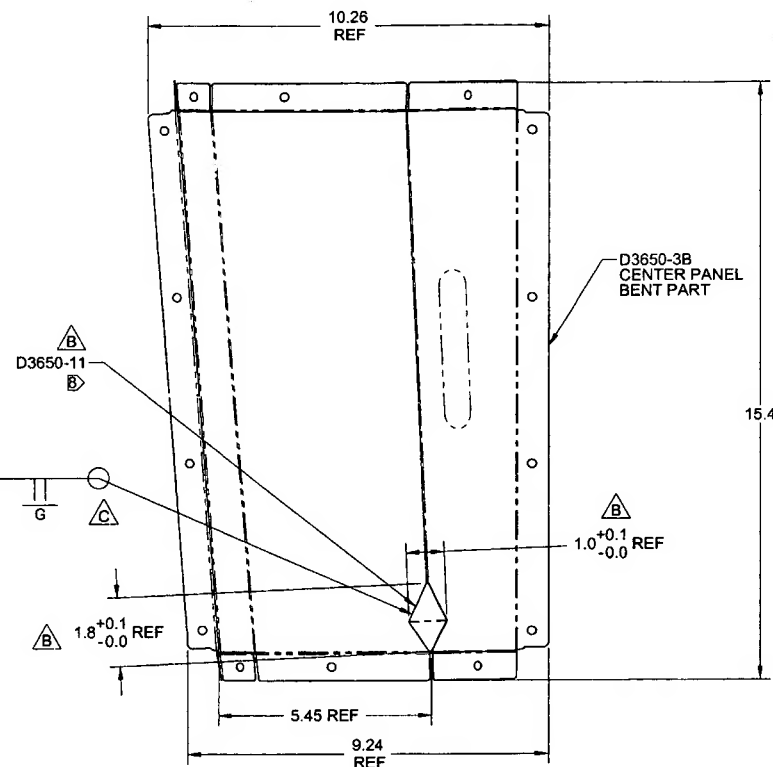
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DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3650</b>	SHEET 3 OF 9
APPROVED		TITLE	SCALE
DE APPR.		<b>TOP PANEL ASSEMBLY</b>	NTS
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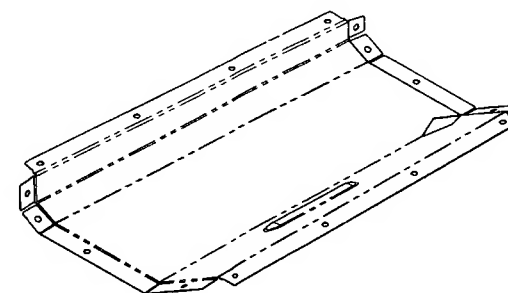


QTY	PART NUMBER	DESCRIPTION
-3		
X	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE

IT IS ACCEPTABLE  
TO GRIND & LEAVE  
0.03 FROM BOTTOM  
FLAT SURFACE



**D3650-3 CENTER PANEL**  
(LOOKING FROM OUT SIDE SURFACE)



DEO ATTACHED

RELEASED  
08.11.17

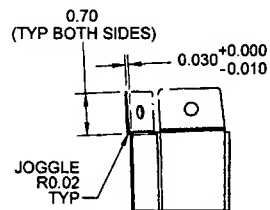
**NOTES:**

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED

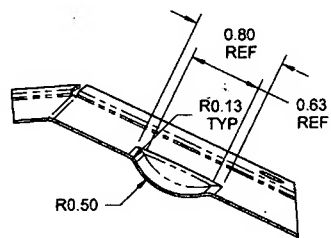
UNDER REVIEW

08.02.03  
08.06.24

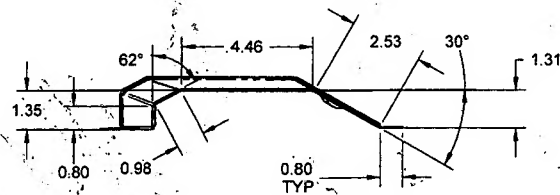
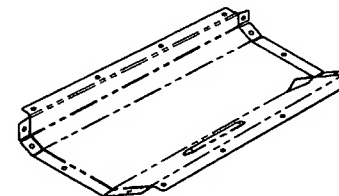
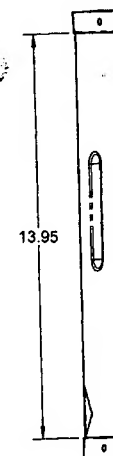
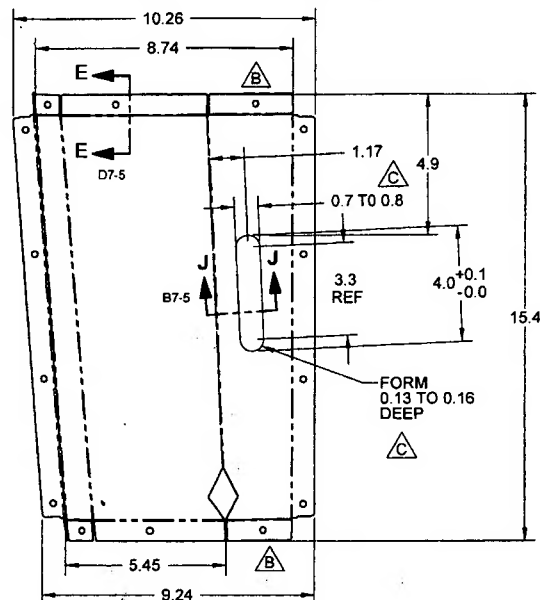
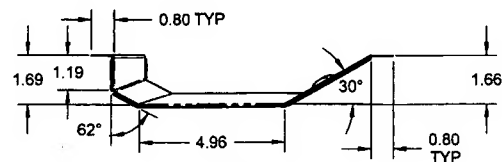
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DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 4 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
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**SECTION E-E** D5-5  
SCALE 2X



**SECTION J-J** C5-5  
SCALE 3.5X







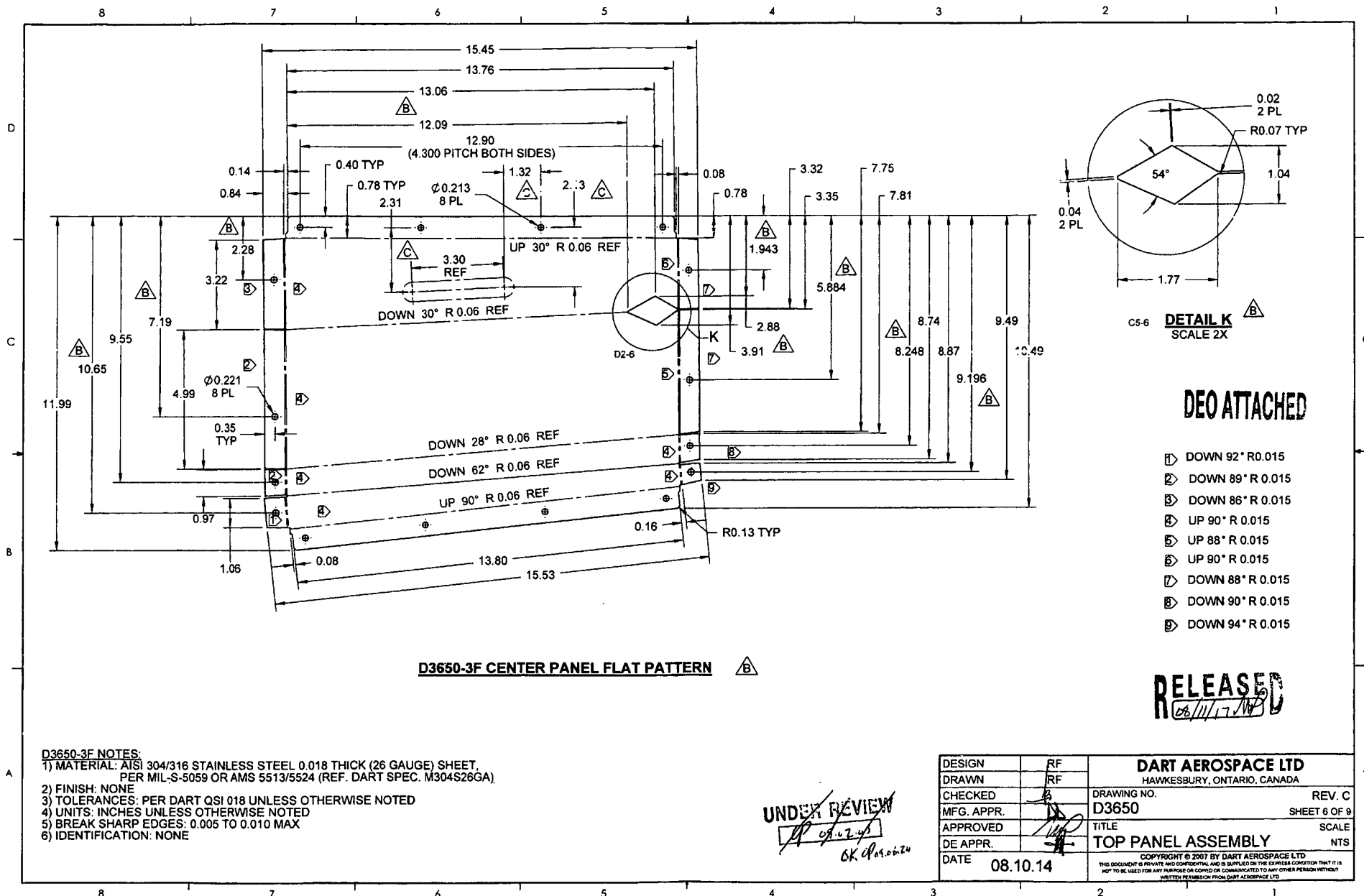
- NOTES:**  
 1) FINISH: NONE  
 2) TOLERANCES: PER DART QSI:018 UNLESS OTHERWISE NOTED  
 3) UNITS: INCHES UNLESS OTHERWISE NOTED  
 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 5) IDENTIFICATION: NONE

**D3650-3B CENTER PANEL BENT PART**  
 (MAKE FROM D3650-3F FLAT PATTERN)

**UNDER REVIEW**

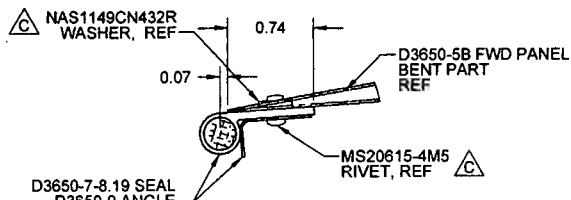
**DEO ATTACHED**  
**RELEASED**  
 6/11/17

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
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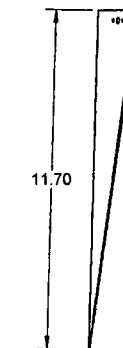
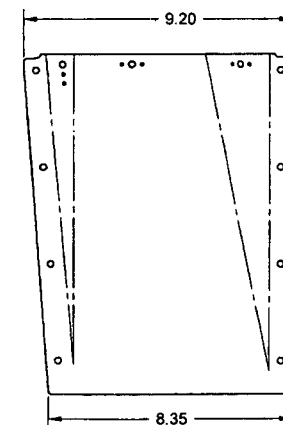
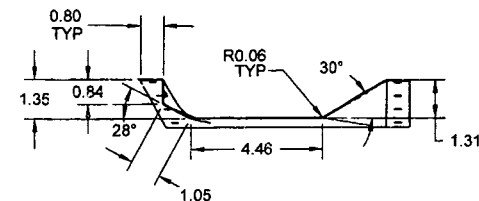


MS21062-3K NUTPLATE  
MS20427M3-3 RIVET, 2 PL  
2 PL

MS21060-3K NUTPLATE  
MS20427M3-3 RIVET, 2 PL  
2 PL



**DETAIL F**  
SCALE 3.5X



DEO ATTACHED

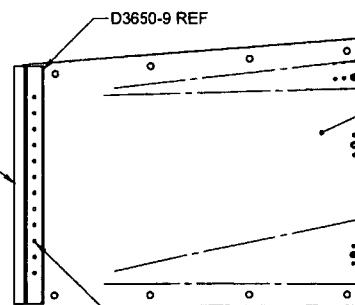
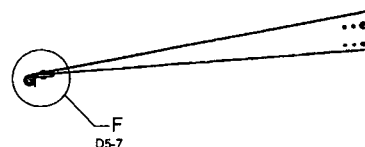
**D3650-5B FWD PANEL BENT PART**  
(MAKE FROM D3650-SF FLAT PATTERN)

**RELEASED**  
08/11/17

**PART LIST**

QTY -S	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

D3650-7-8.19  
REF



CENTRE D3650-7/-9 ON D3650-5B &  
TRANSFER Ø0.129 (#30 DRILL) HOLES  
FROM D3650-9 TO D3650-7 & D3650-5B  
AS SHOWN  
INSTALL  
MS20615-4M5 RIVET  
NAS1149CN432R WASHER  
12 PL

**D3650-5 FWD PANEL**

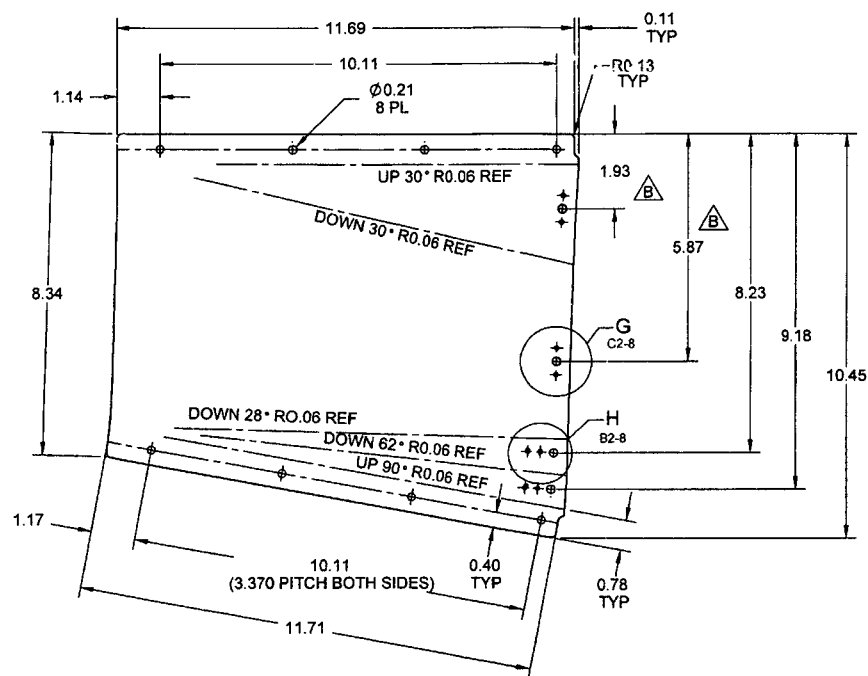
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,  
PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs

**UNDER REVIEW**  
08/09/17  
08/11/17

DESIGN	RF	<b>DART AEROSPACE LTD</b>
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. <b>D3650</b> REV. C
MFG. APPR.		SHEET 7 OF 9
APPROVED		TITLE <b>TOP PANEL ASSEMBLY</b> SCALE NTS
DE APPR.		
DATE	08.10.14	

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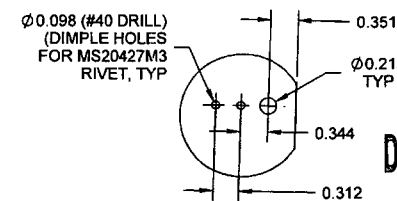
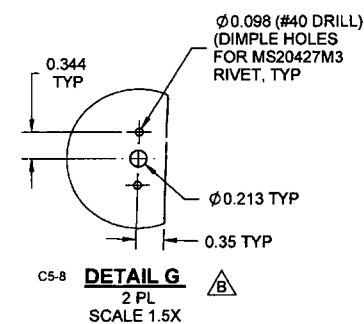
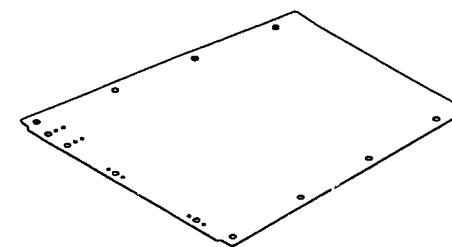


**D3650-5F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

**UNDER REVIEW**  
*[Signature]*  
 CK 4/24/24

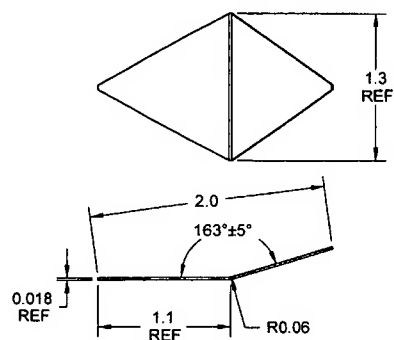


**DEO ATTACHED**

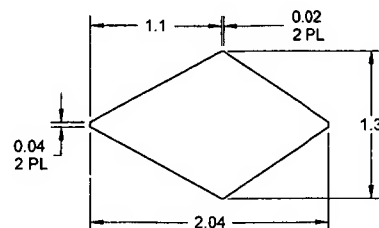
**RELEASED**  
 06/11/17 JLD

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO. <b>D3650</b>	REV. C
MFG. APPR.	[Signature]	TITLE <b>TOP PANEL ASSEMBLY</b>	SHEET 8 OF 9
APPROVED	[Signature]	SCALE	NTS
DE APPR.	[Signature]	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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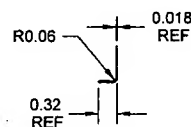




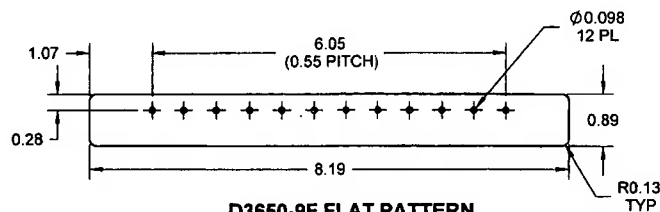
**D3650-11 FILLER PLATE**  
(MAKE FROM D3650-11F FLAT PATTERN)



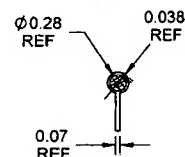
**D3650-11F FLAT PATTERN**



**D3650-9 ANGLE**  
(MAKE FROM D3650-9F FLAT PATTERN)



**D3650-9F FLAT PATTERN**



**D3650-7-8.19 SEAL**

**D3650-7-8.19 NOTES:**

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)  
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX  
WHERE X.XX = LENGTH IN INCHES  
EG. 12.50" LONG = D3650-7-12.50





**D3650-9 & D3650-11 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,  
PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb  
D3650-11 WEIGHT: 0.007 lb

**UNDER REVIEW**  
CP 05/07/03  
OK 06/01/04

**DEO ATTACHED**

**RELEASED**  
08/10/14

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. C					
DRAWN	RF			DRAWING NO. <b>D3650</b>	SHEET 9 OF 9			
CHECKED						TITLE <b>TOP PANEL ASSEMBLY</b>	SCALE NTS	
MFG. APPR.								COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.
APPROVED								
DE APPR.								
DATE	08.10.14							





DRAWING NO. D3650	TITLE TOP PANEL ASSEMBLY	REV. C	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>	D.E.O. NO. D3650-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN CP	CHECKED	MFG. APPR. <i>EC</i>	APPROVED <i>MD</i>	DE APPR. <i>MD</i>		
DATE 09.06.12	DATE 04.06.15	DATE 09.06.15	DATE 09/06/15	DATE 09/06/15		

**TO AMEND D3650-5 FWD PANEL:**

REF PAR 09-008. THE QTY(12) NAS1149CN432R WASHERS ARE REPLACED WITH QTY(1) D3893-1 DOUBLER. THE QTY(12) MS20615-4M5 RIVETS ARE REPLACED WITH QTY(12) NAS9307M-4-03 RIVETS. LOCATION OF THE DOUBLER IS SHOWN IN THE AMENDED DETAIL F (DWG SHEET 7) BELOW. THE PARTS LIST FOR D3650-5 IS AMENDED AS FOLLOWS:

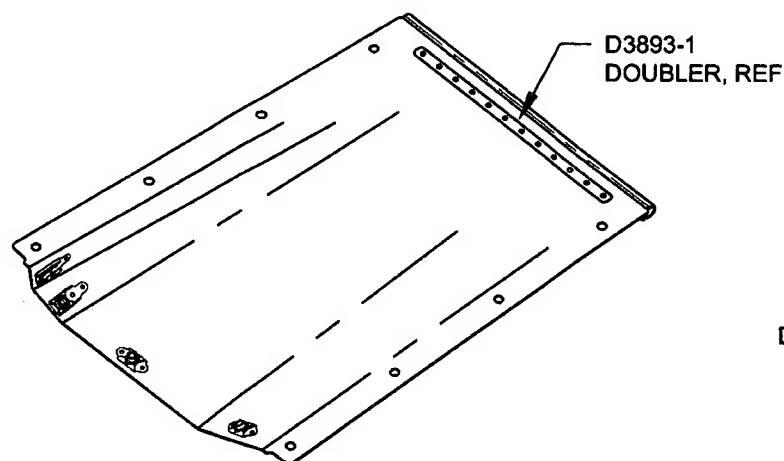
**IS:**

QTY	PART NUMBER	DESCRIPTION
-5		
1	D3893-1	DOUBLER
12	NAS9307M-4-03	RIVET (OR CR3523-4-03)

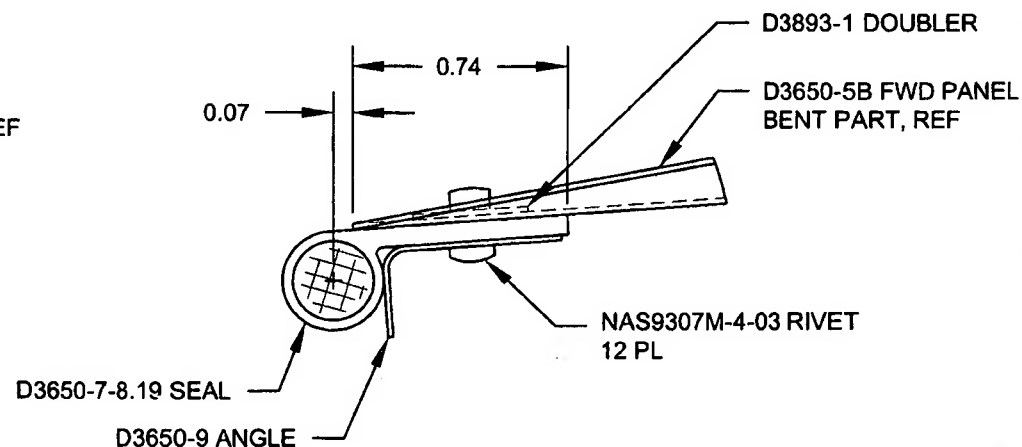
**WAS:**

QTY	PART NUMBER	DESCRIPTION
-5		
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET

**RELEASED**  
09/06/15



**D3650-5 FWD PANEL**



**DETAIL F** C5-7  
SCALE 3.5X

